

Date: Friday, 9/21/2007 1:18:34 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 34814	
Estimate Number : 10533	
P.O. Number : <u>N/A</u>	Part Number : D2573
This Issue : 9/21/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/21/2007 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 34750	Material : <u>N/A</u>
Written By : _____	Due Date : 10/18/2007 Qty: 8 Um: Each
Checked & Approved By : <u>JA 07.09.24</u>	
Comment : Est. As Per RevE 06-01-27 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2573  
 Ensure that grain is along 7.75" length  
 Batch No: 6 31589

SG 07.10.15

⑧

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. SG Double check by: JML

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

SG 07.10.16 ⑧

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574

SG 07.10.16 ⑧

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG 07.10.16 ⑧

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 9/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/21/2007 1:18:34 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34814

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/17

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-10-18

(8)

7.0

POWDER COATING

POWDER COATING



M105068



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-J

07/10/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-10-22

(X8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/10/23 SP

8X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/23

(8)

Job Completion



U 07/10/23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34814
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		.510	.510	.510	.510		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.501	.500	.500		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.123	.123	.123	.123		
Q	0.115	0.135		.123	.123	.123	.123		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.128	.128	.128	.128		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.352	.352	.352	.352		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.615	.615	.615	.615		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.005	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	36
Date:	07/10/16

Audited by:	J.F.
Date:	07/10/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34814
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5A	6A	7A	8A	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.751	1.751	1.751	1.751		
C	3.495	3.505		3.501	3.501	3.500	3.500		
D	1.745	1.755		1.751	1.751	1.751	1.751		
E	7.990	8.010		8.006	8.003	8.003	8.003		
F	0.490	0.510		.505	.501	.500	.500		
G	0.257	0.262	DT8683	.259	.259	.259	.259		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.503	.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.365	1.365	1.365	1.365		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.138	.138		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.130	.130	.130	.130		
X	0.308	0.313		.313	.313	.313	.313		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.350	.350	.350	.350		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.631	.631	.631	.631		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043							
Accept/Reject									

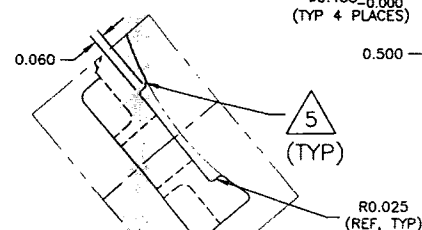
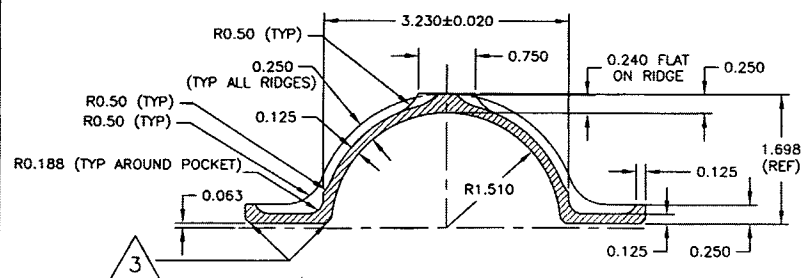
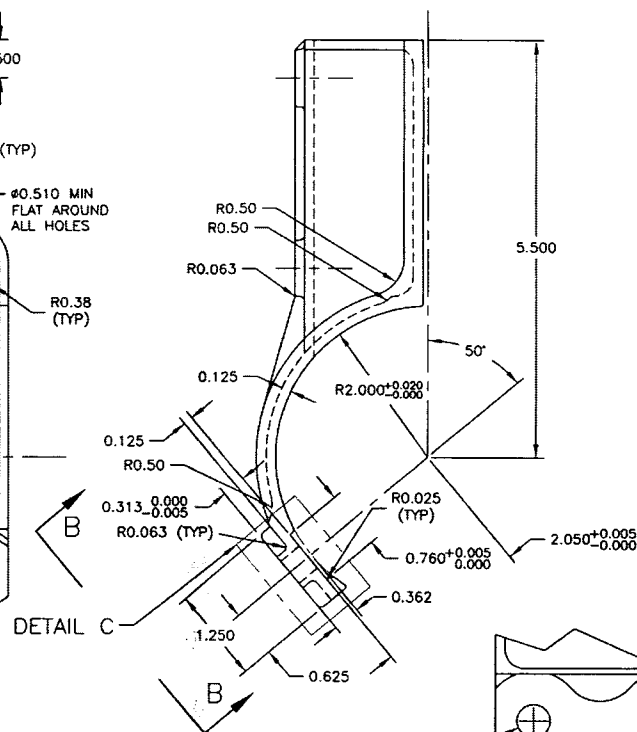
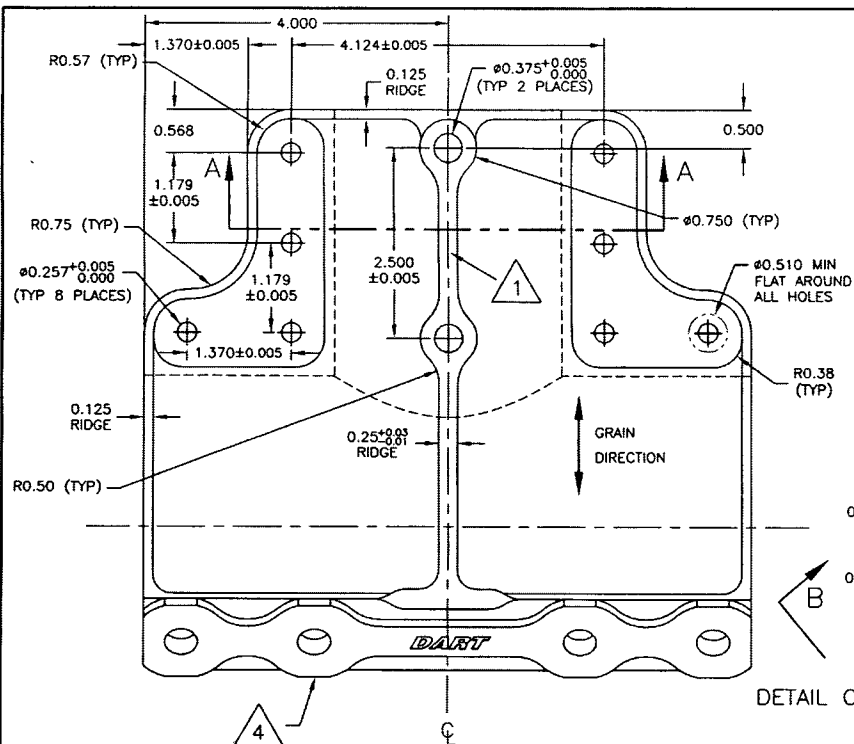
Measured by: J.F.
Date: 07/10/16

Audited by: J.F.
Date: 07/10/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06 #

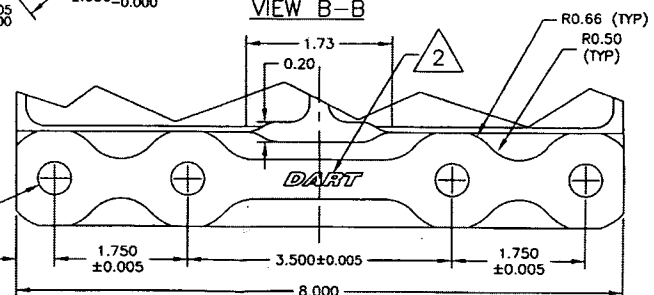
DETAIL C  
SCALE 4:3

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  
3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
4 CHAMFER 0.063" x 45° ALL AROUND  
5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

## VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA	REV. E
CHECKED #	APPROVED #	DRAWING NO. D2573	SHEET 1 OF 1
DATE 05.07.13	TITLE OUTER AFT SADDLE	SCALE 2:3	

NO. 34814  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY